Rush

Quality Control

Work Order ID 106023 August-28-13 12:31:15 PM				*106	3023*						Page 1
Item ID: Revision ID:	D3933-1		F	Accept	*N900	040	100)* s	etup Sta	rt *N	S1*
Item Name:	Aft Wall Prote	ector 1							Sto	^p *N	S2*
Start Date: Required Date: Reference:	8/23/13 : 8/28/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	ID:					
Approvals:	Process Pla	in: MLJ	Date: 13-08-29	Tooling:	D	ate:		R	un Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	D	ate:		Stop		*N	R2*
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3933	A										·
100				0.00				1			4
100 Waterjet FLOW CNC Water	rjet	Dwg Rev: Prog Rev:		0.00				<u>4</u> _	O		<u>Ae</u> 13.10.24
110		QC2- Inspect parts off	f machine FAI/FAIB	0.00				:/			1
*11 0 * ^{QC}		Memo		0.00				_ 7	_0		13.10.24

											DQA:	Date:			
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE					
											QA Closed:	Date			
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	-					Rework			Skid-tube Crosstube		Water Jet		Engineering		
Part N	۱o								Small Fab	4	d. Eng. Coor.	Quality			
NCR No.					Finishing Composite	Rec/Sto	re/Packaging Supplier	Other							
Root					Descri	ption of work order update		Initial	Act	tion	Sign &				
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data							П								
Equip/Tooling															
Operator															
Material						·									
Setup															
Other															
Process			ł												
Supplier							-								
Training	П		i				İ								
Unapproved			1												
						F	AUI	LT CATE	GORY						
Landi	ng G	iear				General					_				
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S			o/s	BOM/Route					Over/Under tolerance Temperatur					

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Broken/Damaged

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde August-28-13 12				*106	3023*						Page 2
Revision ID:	D3933-1			Accept	*N900	040 ′	100	* s	etup Start	ı VI.	S1* S2*
Start Date: Required Date: Reference:	8/23/13 8/28/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Approvals:	Proces QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Stop	171	R1* R2*
Sequence ID/ Work Center II 120 *120 CQC Quality Control	D	Operation Description QC8- Inspect parts - seco	and check	Set Up/ Run Hours 0.00 27 9-89 0.00 3 6	1		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130 Packaging Packaging		Identify as per dwg & St Memo	ock Location:	0.00				_4x	DAS 28 9-89	<u> 3-</u>	10-25
140 *140* QC		QC21- Final Inspection Memo	- Work Order Release	0.00				(H)/A	1 <u>3-1</u>	9-28

Quality Control

W 13-10-25

											DQA:	υa	ite:			
NCR: Y	'es	/ No				WORK ORDER NON-O	O	VFORN	MANCE / UPD	ATE	QA Closed:	Da	ite:			
Monte Ondon						DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Work Order: Part No. NCR No.				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other					
Root			Descri		Descri	ption of work order update		Initial	nitial Action		Sign &					
Cause	- 1	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector		
Doc/Data													l			
Equip/Tooling																
Operator																
Material						•										
Setup																
Other			ĺ					i								
Process			İ	ļ												
Supplier																
Training			Ì													
Unapproved																
						F	AUI	LT CATE	GORY		***					
Landi	ng G	iear			_	General	_	-			7			1		
	Bending Bend			Bend		Grain			Ovalized			Pressure/Forced				
	Ш	Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Unde	tolerance		Temperature/Cure		
	Ш	Cracks				Broken/Damaged		- i	Inspection Incomplete			ct	Weld			
		Crushed/	Crimped		L	Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing		Wrong Stock Pulled		
	Cuffs				Contamination	1	Maintenance			Part Moved						

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short Drill Holes

Drawing Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-28-13 12:31:15 PM

Work Order ID:

106023

Parent Item:

D3933-1

Parent Item Name:

Aft Wall Protector

Start Date: 8/23/13

Required Date: 8/28/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,471.4520	7.01	16.494118	${A}$	13	10.20
GE PLASTICS LEXAN S	HEET			Location		Loc Qty	Lo	c Code	6000			<u> </u>	
				MAT018		2471.452							
				1248	66	286.792					_	99	613
				<u>m126</u>	5425	2184.66			<u> </u>	24425		33.	00

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Prod. Eng. Coor. Quality Small Fab Part No. Scrap Machining Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Large Fab Composite Supplier NCR No. Work Order Update Description of work order update Action Sign & Initial Root **Chief Eng** Verification QC Inspector or Non-conformance Description Date Qtv Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware

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Turning Sequence

Wave/Twist in Tube

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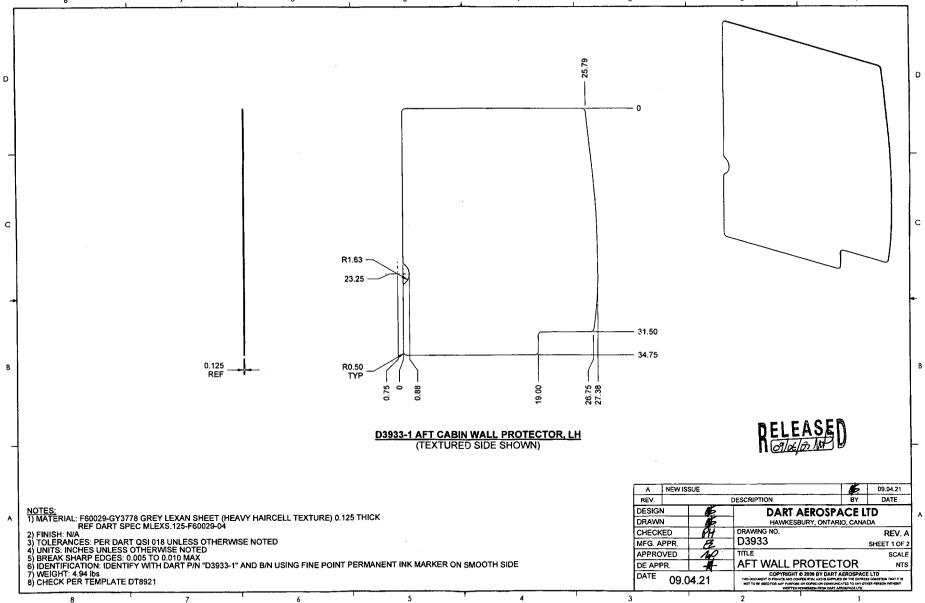
DART AEROSPACE LTD	Work Order:	106023
Description: Aft Cabin Wall Protector, LH	Part Number:	D3933-1
Inspection Dwg: D3933 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
0.88	+/-0.030	'88"	-		V	Dkm-01				
19.00	+/-0.030	19.00"			T	UKM-06				
26.75	+/-0.030	26.75"								
27.38	+/-0.030	27.38"	_		T					
34.75	+/-0.030	34,75"			T					
31.50	+/-0.030	31.50"	_		T					
25.79	+/-0.030	25.79"	-		T					
0.125	+/-0.010	.127"	_		· V	JKM-01				
23.25	+/-0.030	23.25"	_		Τ	·				

L		DAS		
Measured by: A	Audited by:	27	Prototype Approval:	N/A
Date: 13 · 10 · 24	Date:	R.023	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.06.22	New Issue	KJ : 554	1 /K



J. 500 W. ENGINEED INC. ENCONTRACTOR CORY SUBJECT TO AME DIDMENT WYSBALL OF ICE 106023 MLJ 13.08.29

